

Work Order ID 67993

Tuesday, April 05, 2011 10:44:28 AM

Page 1

Item ID: D4380-13
Revision ID: PRELIM
Item Name: Panel, RH Oxygen and Oxy Minder
Start Date: 4/5/2011 Start Qty: 1.00
Required Date: 4/5/2011 Req'd Qty: 1.00
Reference:

Accept

Setup Start

Stop

Cust Item ID:
Customer:

PRELIMINARY ISSUE

Run Start

Stop

Approvals: Process Plan: *ME* Date: *11-04-05* Tooling: Date:
QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Setup/ Run Hours	Pool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	---------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4380	<i>PA6 PA7 Wh 11/04/06</i>

100



HandThermo

Hand Finishing Thermoforming

Memo

1-Cut Sheet to required Blank size

0.00

105



HandThermo

Hand Finishing Thermoforming

Dry Material

Memo

Dry Sheet as per QS1022 Kydex

0.00

0.00

Temp:

150°

Time IN:

6:00 PM 11/04/06

Time OUT:

*7:00 AM 11/04/06**BB 11/04/06**BB 11/04/06*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Accept

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

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Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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110

0.00



Thermoform

Thermoforming Machine

Memo

1-Machine Set-Up
2-Pre-heat Tool to required temp.
3-Thermoform as per Dwg and Folio #FTA116 using tool DT9741

Dwg Rev: PA7Folio Rev: A

0.00

120

0.00



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

Visually inspect part for proper formation and texture

0.00

130

0.00



QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

11/04/06

11/04/06

11/04/06

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Item ID: D4380-13

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Setup Start



Revision ID: PRELIM

Stop



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Start Date: 4/5/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/5/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

0.00



HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Trim to finished dimensions as per Dwg

DL
11/04/06

150

0.00



QC

Memo

0.00

Quality Control

Complete FAI document



BB
11/04/06

160

0.00



QC

Memo

0.00

Quality Control

QC5- Inspect part completeness to step on W/O

inspected to part

Don only

8/10/07 @

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Page 4

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Revision ID: PRELIM

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Item Name: Panel, RH Oxygen and Oxy Minder

Start Date: 4/5/2011 Start Qty: 1.00



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Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170

Identify as per dwg & Stock Location: RDG6

0.00



Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

POSITIVE RECALL

EFFECTIVE 4/4/05 AUTH cu

RELEASED _____ DATE _____

802370
SCRAPPED

FOR DAN CAMPBELL

W/O:		WORK ORDER CHANGES					
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Picklist Print

Tuesday, April 05, 2011 10:44:26 AM

Page 1

Work Order ID: 67993



Parent Item: D4380-13



Parent Item Name: Panel, RH Oxygen and Oxy Minder

Start Date: 4/5/2011

Required Date: 4/5/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: Rev. A New Issue, 11/04/04 DL verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MKYD100S.080-P1- 52114		Purchased	No			100	sf	22.3000	6.9375	6.9375			



Kydex 100 .080



Location

Loc Qty

Loc Code

therm

22.3

22.3

16510

6.9375 sq ft

Sh.
11/04/06

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:
Description: PANEL 2XY+ 01YN.1002		Part Number: D438-13
Inspection Dwg: 4380-13 Rev: PA7		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST
THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: BB

Date: 11/04/06

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
14.0	.100	14.0	✓			
13.75	.030	13.70	✓			
11.75	.030	11.75	✓			

Measured by: BB

Date: 11/04/06

Audited by: S to Part Draw only

Date: 4/04/07

Preliminary Approval:

Date:

Rev	Date	Change	Revised by	Approved
B	10.04.14	Added preliminary approval	KJ	

10.04.14

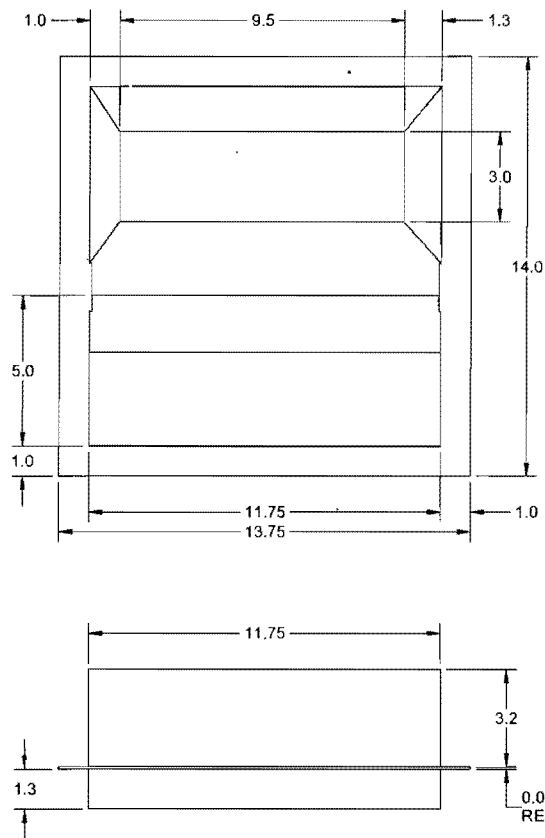
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

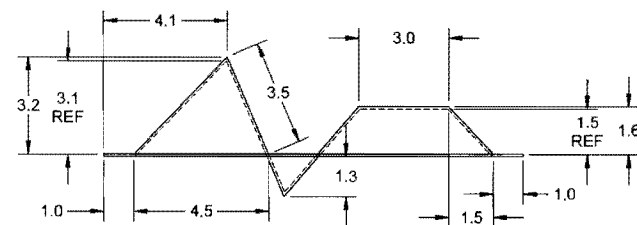
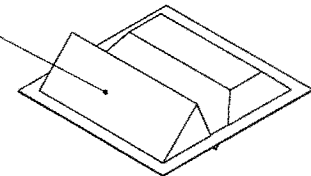
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NOTE: Date & initial all entries



TEXTURED SIDE
ON REVERSE



D4380-13 PANEL, RH OXYGEN AND OXY MINDER

NOTES:

- 1) MATERIAL: KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015
REF DART SPEC MKYD6185S.080-P3-62015
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 1.14 lbs
- 8) MINIMUM ALLOWABLE THICKNESS AFTER THERMOFORMING = 0.040
- 9) TOOLING: THERMOFORM -13 PART PER MOULD DT9741.
TRIM PER MOULD LEAVING FINISHED EDGE.

PRELIMINARY ISSUE

11.04.05

DESIGN	DL	DART AEROSPACE LTD	
DRAWN	DL	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA7
MFG. APPR.		D4380	SHEET 7 OF 18
APPROVED		TITLE	SCALE
DE APPR.		CEILING POCKETS	NTS
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W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Daryl Leger

From: Daniel Campbell <dcampbell@dartaero.com>
Sent: Monday, April 04, 2011 9:16 AM
To: 'Daryl Leger'
Cc: 'JEANLUC MENARD'; Bill Beckett; 'Linda Lacelle'; 'Harvey Siemens'; 'Mike Petsche'
Subject: D4323 & D4380 - Parts can be untrimmed

To Whom It May Concern,

The parts with p/n's D4323-XX and D4380-XX can be shipped to Calgary untrimmed, or even slightly out of spec in order to get parts here asap so they can be installed on the Westpac machine.

Thanks,

Daniel Campbell
Mechanical Engineer
DART Aerospace Ltd.

P: 403-717-0325
F: 403-717-1288
E: dcampbell@dartaero.com
W: www.dartaero.com
M: 1060 McTavish Road, NE, Calgary, Alberta, T2E 7G6

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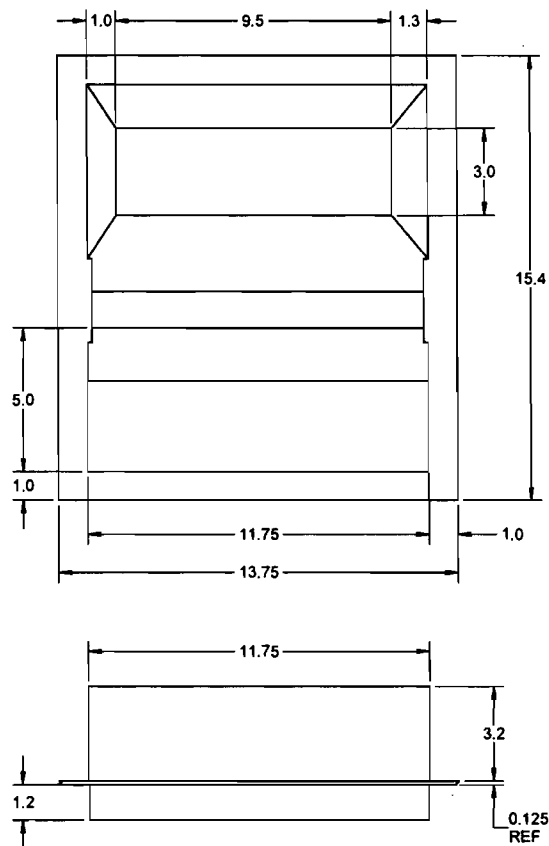
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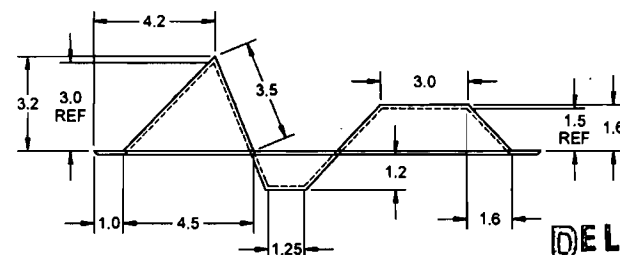
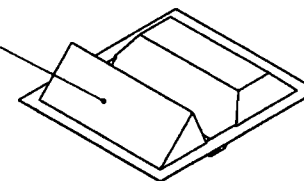
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TEXTURED SIDE
ON REVERSE



RELEASED
2011-05-10

D4380-13 PANEL, RH OXYGEN AND OXY MINDER

NOTES:

- 1) MATERIAL: KYDEX 6185, 0.125 THICK, P3-VELOUR MATTE, IVORY #62015
REF DART SPEC MKYD6185S.125-P3-62015
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4
- 7) WEIGHT: 1.89 lbs
- 8) MINIMUM ALLOWABLE THICKNESS AFTER THERMOFORMING = 0.040
- 9) TOOLING: THERMOFORM PER MOLD DT9741 AND DART QSI 022
- 10) TRIM PER MOLD LEAVING FINISHED EDGE
- 11) MAXIMUM INSIDE RADIUS = 0.188

DESIGN	DC	DART AEROSPACE LTD	
DRAWN	DC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	BE	DRAWING NO.	REV. A
MFG. APPR.	BE	D4380	SHEET 7 OF 19
APPROVED	BE	TITLE	SCALE
DE APPR.	BE	CEILING POCKETS	NTS
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